

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014308**Date Inspected:** 20-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Bnifacio Daquing, Wm. J. McConnell			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2W/3W-C, 1W/2W-C/D and the following observations were made:

2W/3W-C1

The QA Inspector randomly observed the ABF welders Song Tao Huang and Jin Quan Huang had previously started the induction heating blankets to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector noted the FCAW root pass of the above identified weld segment was started on the previous day shift. The QA Inspector randomly observed the SE QC Inspector identified as Bernard Docena set the FCAW machine to the parameters of the approved WPS. The QA Inspector randomly observed the FCAW parameters were 252Amps 23.7Volts and a travel speed of 290mm/min. The QA Inspector randomly observed the ABF welder Song Toa Huang begin the FCAW fill pass. Near the end of the QA Inspectors shift it was noted the ABF welder experienced porosity intermittently through out the majority of the weld segment. The QA Inspector noted the remainder of the QA Inspectors shift was spend grinding in an attempt to remove the porosity.

5E/6E-A

The QA Inspector noted no additional work or fabrication was performed by the ABF at the above identified location on this date. The QA Inspector noted ABF welders were relocated to other locations where production welding was performed.

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1W/2W-D/S

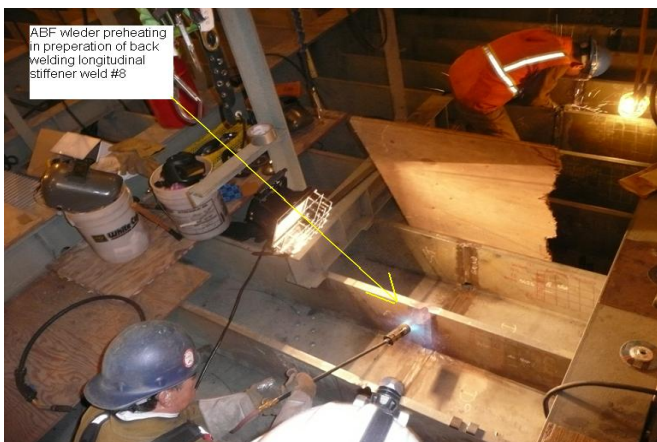
The QA Inspector randomly observed the ABF welders Chun Fai Tsui and James performing grinding tasks of the longitudinal stiffeners upon the arrival of the QA Inspector. The QA Inspector noted approximately 13 total vertical weld joints for the longitudinal stiffener plates had been completed. The QA Inspector randomly observed the ABF welder James Zhen set up and begin preheating the previously back gouged weld joint of the longitudinal stiffener plate identified as #8. After the minimum required preheat of 200°F had been achieved, the QA Inspector noted the ABF welder began performing the FCAW root/fill passes. The QA Inspector noted the SE QC Inspector Bnifacio Daquinag was present and monitoring the FCAW parameters. The QA Inspector noted the FCAW parameters were 231 Amps, 21.7 Volts and a travel speed of 140mm/min. The QA Inspector noted the FCAW parameters appeared to be in general compliance with ABF-WPS-D1.5-3110-3. The QA Inspector noted the stiffener plate identified as #8 was completed on this date. The QA Inspector noted the ABF welder Chun Fai Tsui was performing grinding tasks of the previously completed vertical stiffener plates. The QA Inspector noted the ABF welder was removing the weld reinforcement.

2W/3W-E

The QA Inspector noted the above identified weld joint was previously completed on the inside of the OBG. The QA Inspector noted the ABF welder identified as Mike Maday was performing plasma arc gouging, of the external surface of the weld joint. The QA Inspector noted the back gouging was in process for the remainder of the QA Inspectors shift.

1W/2W-E

The QA Inspector randomly observed the SE QC Inspector identified as Steve McConnell begin performing Ultrasonic Testing (UT) of the previously completed weld. The QA Inspector did not observe the QC Inspector locate any rejectable weld defects on the QA Inspectors shift.



Summary of Conversations:

No pertinent conversation noted.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
